

Date: Monday, 04/05/2009 1:45:45 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT
Job Number :	47677		
Estimate Number :	10219		
P.O. Number :		Part Number :	D219923
This Issue :	04/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2199 REV. E1
First Issue :	1/1	Project Number :	N/A
Previous Run :	40195	Drawing Revision :	E1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/05/2009
Written By :		Qty:	8 Um: Each
Checked & Approved By :	<u>JUD 09.05.06</u>		
Comment :	Est:D 02.06.10 Rem polish & add finishNG/CC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.3100 f(s)/Unit Total : 13.8600 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M 111619

80 09/05/27 8

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 09/05/27 8

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Debur

M-L 09/05/27

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8 09/05/27 (8X)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 7:30 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00 AM

JP 09-05-28 (XJ)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:45:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 47677

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/05/28

(8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST264

SS 09/05/28

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/28

Job Completion



MF 09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

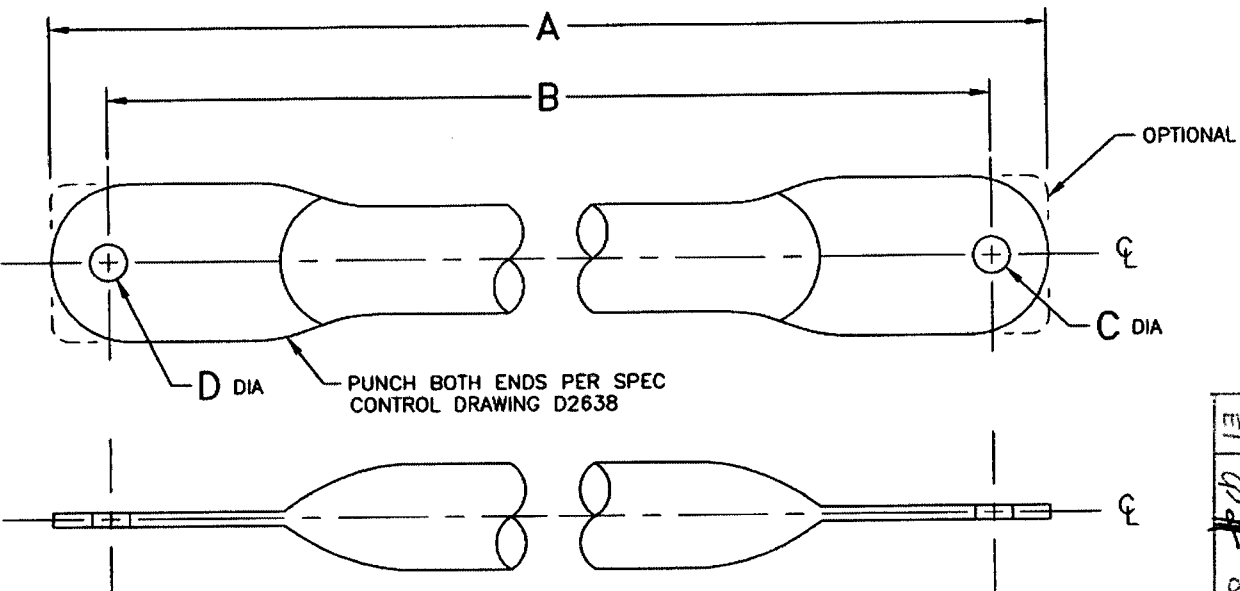
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	D2199	SHEET 1 OF 1
98.04.28	TITLE	STRUT DETAILS	SCALE
			NTS
A	1993	NEW ISSUE	
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
E1	98.05.22	ADD FINISH	



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B B B C C C D D E E

100.10.13
100.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART Q51 Q55 +3/E1

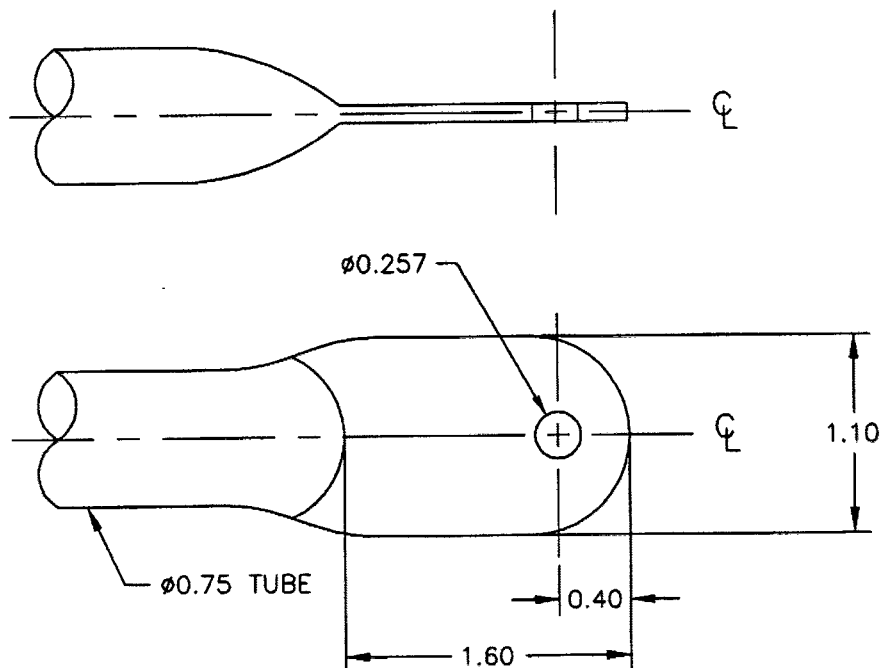
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NO. 47027



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MO	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
4/5/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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